

Work Order ID 58269

May 3, 2010 9:52:02 AM



Page 1

Item ID: D2938-2

Accept



Setup Start



Revision ID:

Item Name: Saddle RH Out, 206

Stop



Start Date: 03/05/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 03/05/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date: 10-5-03

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2938

Rev C

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

B.A 10/05/19

4

0

HAAS CNC vertical machine #1

Program part number and batch number. ☒ 1-Inspect part number and batch number are programmed correctly. ☐ 2-Machine Step No 1 of Folio and visually inspect as per dwg D2938 & attached Dimension Sheet ☐ 3-Machine Step No 2 of Folio and visually inspect as per

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

B.A 10/05/19

4

0

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

B.A 10/05/19

4

0

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

DJP 10/05/20

4

Ø

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

H BR 10-5-21

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

M 114207 7 J 10/05/21

4

Ø

Powder Coating

START TIME: 11:00am FINISH TIME: 3:09pm OVEN TEMPERATURE:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 58269

May 3, 2010 9:52:02 AM



Page 3

Item ID: D2938-2

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Setup Start



Revision ID:

Stop



Item Name: Saddle RH Out, 206

Start Date: 03/05/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 03/05/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10-5-21

SP (4K)

170

Identify as per dwg & Stock Location: 422A

0.00



Packaging

Memo

0.00

Packaging

10-5-21

SP

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/259

MF

10-5-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May 3, 2010 9:52:06 AM

Page 1

Work Order ID: 58269



Parent Item: D2938-2



Parent Item Name: Saddle RH Out, 206

Start Date: 03/05/2010

Required Date: 03/05/2010

Comments: IPP: B ☐ 00.06.26 ☐ New DWG rev (mpp 2069) ☐ EC ☐
IPP Rev: C As per Rev C 07-03-19 JLM ☐

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D6101-003		Manufactured	No			100	Each	22.0000	1			



Saddle Billet, 7075



Location

Loc Qty

Loc Code

MAT45

22

46410

22

4.0

G.A 10/05/19

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	58269
Description: 206 Saddle, Outboard, Right side	Part Number:	D2938-2
Inspection Dwg: D2938 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2938 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		0.132	0.132	0.132	0.132		
B	0.100	0.140		0.130	0.130	0.130	0.130		
C	0.100	0.140		0.125	0.125	0.125	0.125		
D	0.210	0.230		0.221	0.221	0.221	0.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		0.512	0.512	0.512	0.512		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		0.259	0.259	0.259	0.259		
L	0.312	0.317		0.315	0.315	0.315	0.315		
M	0.235	0.240		0.237	0.237	0.237	0.237		
N	0.100	0.140		0.110	0.110	0.110	0.110		
O	0.540	0.560		0.551	0.551	0.551	0.551		
P	0.490	0.510		0.502	0.502	0.503	0.502		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.720	2.760		2.747	2.747	2.747	2.747		
S	0.240	0.270		0.253	0.253	0.253	0.252		
T	0.100	0.180		0.135	0.135	0.135	0.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		0.317	0.317	0.317	0.317		
X	1.250	1.270		1.259	1.2595	1.259	1.260		
Y	1.565	1.585		1.571	1.571	1.5715	1.571		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	B. A
Date:	10/05/19

Audited by:	DTA
Date:	10/05/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Reformat; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

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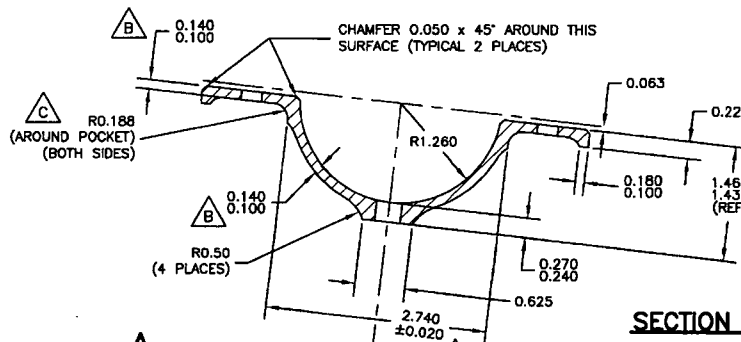
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

SUBJECT TO AMENDMENT

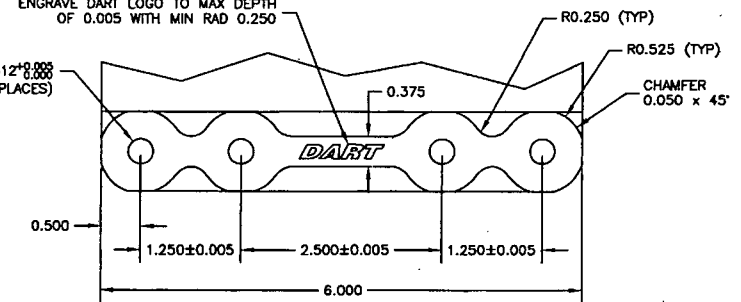
WITHOUT NOTICE
WORK ORDER
NO. 38269

10-5-02

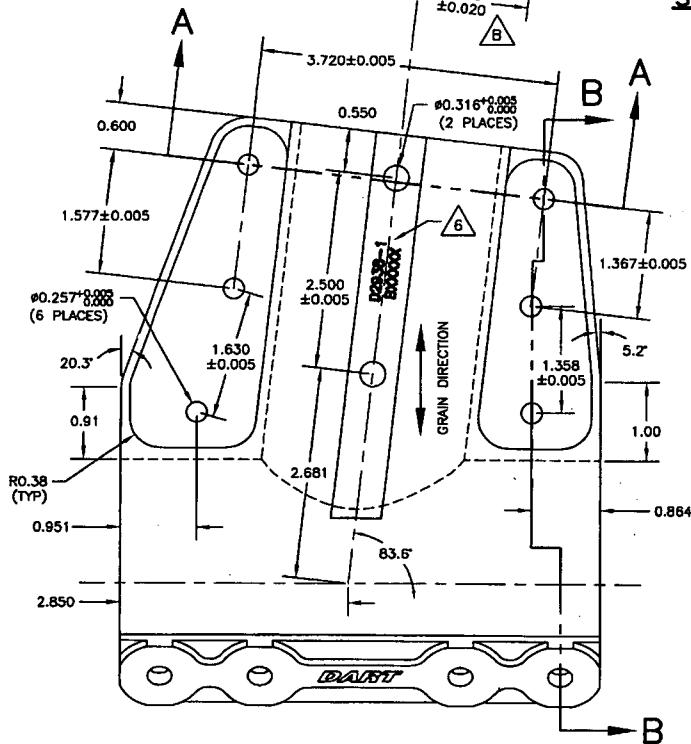
ENGRAVE DART LOGO TO MAX DEPTH
OF 0.005 WITH MIN RAD 0.250



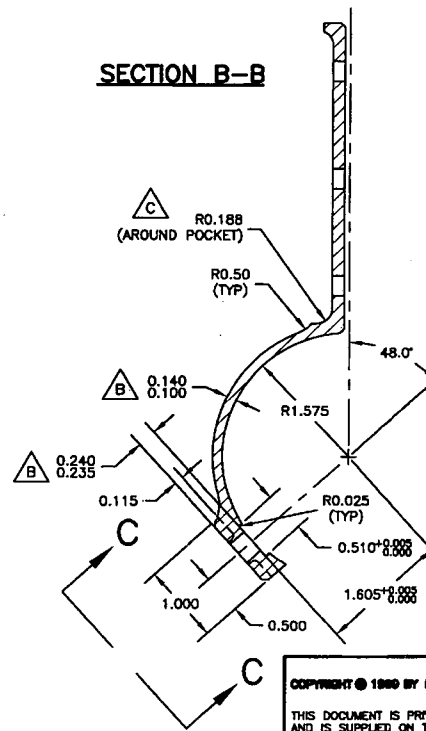
SECTION A-A



VIEW C-C



SECTION B-B



D2938-1 LH SADDLE (SHOWN)
D2938-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	CB	DART DART AEROSPACE USA, INC.
CHECKED	PH	DRAWING NO. D2938
DATE	06.11.09	TITLE: SADDLE OUTSIDE
		REV. C SHEET 1 OF 1 SCALE 2:3

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DART AEROSPACE USA, INC.

RELEASED

07.02.12

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